

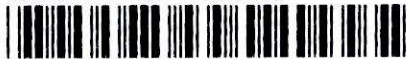


Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2919-2**Job Sheet 204397****Part No:** D2919-2**Job Qty:** 1 pcs**Part Name:** Outer Saddle (Aft RH)**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 12/9/19**Job Tracking No:****Due Date:** 12/13/19**Created By:** Jason Leroux**Type:** Stock**Description:****Note:** DWG D2919 REV.B IPP Rev. A 19.10.28 New issue DP Verify DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	1 pcs	12/13/19		0.00	0.00	HAAS - 1		SBL 19/12/09
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
100	HAAS 4 Axis	1 pcs	12/13/19		2.00	1.88	HAAS - 1 - B4B		SBL 19/12/09
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
110	Conventional Mill - 1 - B4B	1 pcs	12/13/19		0.00	0.13	Conventional Mill - 1 - B4B		SBL 19/12/09
							Conventional Mill - 2 - B4B		
120	QC 2	1 pcs	12/13/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		

**Container No:** S238468**Part:** D2919-2**Job No:** 204397**Serial No/Batch:** S238468**Revision:** B**Inspector:****Exp Date:****Instructions:** Various STC's

Dart Aerospace Ltd.
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Date: 12/09/19

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				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	SBL 19/12/09
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 QC 8	1	12/13/19	0.00 0.00	QC 8 - 12	
	pcs			QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Handfinish - 1-1 Chemical-B4B	1	12/13/19	0.00 0.05	Handfinish - 1 - 1 - B4B	
	pcs			Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	

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					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
145 QC 3	1 pcs	12/13/19	0.00	0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
150 Powdercoat - 1 White GI(A)- B4B	1 pcs	12/13/19	0.00	0.04	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160 QC 3	1 pcs	12/13/19	0.00	0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	

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				QC 3 - 40			
				QC 3 - 19			
				QC 3 - 43			
				QC 3 - 24			
				QC 3 - 61			
				QC 3 - 81			
170 Packaging 3-1 - Stock - B4B	1 pcs	12/13/19	0.00 0.00	Packaging 3 - 1 - B4B			
				Packaging 3 - 2 - B4B			
				Packaging 3 - 3 - B4B			
				Packaging 3 - 4 - B4B			
				Packaging 3 - 5 - B4B			
				Packaging 3 - 6 - B4B			
				Packaging 3 - 7 - B4B			
				Packaging 3 - 8 - B4B			
				Packaging 3 - 9 - B4B			
				Packaging 3 - 10 - B4B			
				Packaging 3 - 11 - B4B			
				Packaging 3 - 12 - B4B			
				Packaging 3 - 13 - B4B			
				Packaging 3 - 14 - B4B			
				Packaging 3 - 15 - B4B			
				Packaging 3 - 16 - B4B			
180 QC 21 - FG	1 pcs	12/13/19	0.00 0.00	QC 21 - FG - 21			
				QC 21 - FG - 70			
				QC 21 - FG - 53			
Part Op 100 - (HAAS CNC Vertical Machine) Program batch number Machine Step No 1 as per Folio FC___ and visually inspect Descriptions: as per Dwg D2919 & attached Dimension Sheet Machine Step No 2 as per Folio FC___ and visually inspect as per Dwg D2919 & attached Dimension Sheet Machine Step No 3 as per Folio 110 - (Manufacture as per dwg) Machine Keyway and inspect per Dwg D2919 & attached dimension sheet 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 145 - (QC3- Inspect Part Finish) 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ 160 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location:_____) 180 - (QC21- Final Inspection - Work Order Release)							
Job BOM							
Part / Item	Component Name	Quantity	Operation	Container			
D6102-010	Saddle Billet	1 pcs (1 ea)	90-Machining - Issue SN				
Job Allocations							
Operation	Component Part	Required	Inventory	Allocated			
90-Machining - Issue SN	D6102-010	1	20	0			
Part Specifications							
Specifications could not be found.							

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Entered: _____ Date: 19/12/09**WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

NCR No. _____

Route update only ☐

Job: <u>204 397</u> Part No. <u>02919-2</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS <table style="width:100%;"><tr><td>Skid-tube ☐</td><td>Cross tube ☐</td><td>Eng. (Non-AW) ☐</td><td>Engineering ☐</td></tr><tr><td>Machining ☒</td><td>Small Fab ☐</td><td>Prod. Eng. Coord. ☐</td><td>Water Jet ☐</td></tr><tr><td>Large Fab ☐</td><td>Finishing ☐</td><td>Rec/Store/Packaging ☐</td><td>Supplier ☐</td></tr><tr><td></td><td></td><td></td><td>Quality ☐</td></tr></table>				Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐				Quality ☐																				
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Date: <u>19/12/09</u>		Sequence #: <u>100</u>		QTY Affected: <u>1</u>		MRB (QSI042) DAS 9 9-89 19.12.09																																					
Description Work Order Deviation				Disposition		Completed By																																					
I extend +11 but I forgot to teach on +61. (+11 use 2 offset) it result of a chamfert to big.				Scrap. and destroyed.		SBL 19/12/09																																					
						Lead hand / Supervisor smf 19/12/09																																					
						QC / QA Coordinator DAS 9 9-89 19.12.09																																					
Root Cause <table style="width:100%;"><tr><td>Operator ☒</td></tr><tr><td>Manufacturing Process ☐</td></tr><tr><td>Equip/Tooling ☐</td></tr><tr><td>Handling/Preservation ☐</td></tr><tr><td>Material ☐</td></tr><tr><td>Product Improvement ☐</td></tr><tr><td>Process Improvement ☐</td></tr><tr><td>Human Factors ☐</td></tr></table>		Operator ☒	Manufacturing Process ☐	Equip/Tooling ☐	Handling/Preservation ☐	Material ☐	Product Improvement ☐	Process Improvement ☐	Human Factors ☐	FAULT CATEGORY <table style="width:100%;"><tr><td>☐ Pressure/Forced</td><td>☐ Contamination</td><td>☐ Power Loss/Surge</td><td>☐ Positioned Wrong</td></tr><tr><td>☐ Bending</td><td>☐ Misaligned/off center</td><td>☐ Folio/Program</td><td>☐ Outside Tolerance</td></tr><tr><td>☐ Crushing</td><td>☐ BOM/Route</td><td>☐ Grain Direction</td><td>☐ Drawing</td></tr><tr><td>☐ Cracks</td><td>☐ Broken/Damage/Defect</td><td>☐ Weld</td><td>☐ Finish</td></tr><tr><td>☐ Crimp/Kink/Ripple/Wave/Twist</td><td>☐ Incomplete/Unclear Instructions</td><td>☐ Wrong Stock Pulled</td><td>☐ Part Lost/Missing</td></tr><tr><td>☐ Marks/Chatter</td><td>☐ Drill Holes</td><td>☐ Out of Sequence</td><td>☐ Misread</td></tr><tr><td>☐ Mislabeled</td><td>☐ Fit/Function</td><td>☒ Off-set/Set-up</td><td></td></tr></table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☒ Off-set/Set-up	
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